

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:**Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-006528**Date Inspected:** 20-Apr-2009**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1900**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** ZPMC and ABF**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** SAS tower**Summary of Items Observed:**

On this date Caltrans OSM Quality Assurance(QA) Inspector, Wai Pau, was present during the times noted above for observations relative to the work being performed.

Bay #11 East and West Tower Shop

East Tower Lift #1:- Caltrans QA Inspector observed ten ZPMC workers installed corner diagonal stiffeners on the skin plates A to E. The locations for installing corner diagonal stiffeners are from 9m to 47.6m. The SMAW tack welding has been applied on the corner diagonal stiffener joints after the fit up accepted by ZPMC and ABF QC. Based on Caltrans QAI observations, no discrepancies were noted.

West Tower Lift#2:- Caltrans QA Inspector observed four welder performed FCAW process on fit lug welds of diaphragm that connected skin plate C. The fit lug welds are located at elevation 53m to 80.7m diaphragm section. The FCAW was monitored and recorded by ZPMC and ABF QC inspector. Based on Caltrans QA inspector observations, no discrepancies were noted.

West Tower Lift#1:- Caltrans QA Inspector observed four welder performed FCAW process on diaphragm that connected skin plate C. The diaphragms are located at elevation 9m to 47.6 diaphragm section. The FCAW was monitored and recorded by ZPMC and ABF QC inspector. Based on Caltrans QA inspector observations, no discrepancies were noted.

East Tower Lift #2:-Caltrans QA Inspector observed a welder performed FCAW repair process on inner corner

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longitudinal seam weld that connected skin plate C and D. The FCAW repair weld area have been repair by ZPMC UT test and located at elevation 59m to 65m diaphragm section. The FCAW repair welding was monitored and recorded by ZPMC and ABF QC inspector. Based on Caltrans QA inspector observations, no discrepancies were noted.

Unless otherwise noted, all work observed on this date appeared to generally comply with applicable contract documents.

Summary of Conversations:

As noted within the report above.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Serge Sinevod 13482570045, who represents the Office of Structural Materials for your project.

Inspected By:	Pau,Wai	Quality Assurance Inspector
Reviewed By:	Clifford,William	QA Reviewer
